

23/05 G/LIT

Date: Friday, 16/05/2008 7:50:14 AM  
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : WEARPLATE

Job Number : 39313

Estimate Number : 10606

P.O. Number :

This Issue : 16/05/2008 S.O. No. :

Prsht Rev. : NC

First Issue : / / Type : SMALL /MED FAB

Previous Run : 38091

Part Number : D33193

Drawing Number : D3319 REV. B

Project Number : N/A

Drawing Revision : B

Material :

Due Date : 23/05/2008

Qty: 12 Um: Each

Written By : 

Checked & Approved By : 

Comment : Est: A 05/05/12 New issue KJ/JLM  
Est Rev:B Now on Waterjet 06-10-03 JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M1010S18GA

1010/1025/A21/6aA SHEET .048



50.



Comment: Qty.: 3.4150 sf(s)/Unit Total : 40.9802 sf(s)

1010/1025/A21/6aA SHEET .048" Thick

Batch: 106603 HB 8-5-20

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3319

Dwg Rev: B HB 8-5-20

Prog Rev: B

2-Deburr if necessary HB 8-5-20

14

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



HB 8-5-20



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

5 08/05/20 (XIV)

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary

Done at step 4.2

N/A 5/20

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form using DT8326 & DT8261 as per Dwg D3319 Rev: B

SP 08/05/21

(11)

7.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

S 08/05/21 (+K)

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld hard surface using D3319-3T2 per QSI 004 and Dwg D3319 Rev: \_\_\_\_

Qty Part Number Description Batch

A/R N/A 7560 Hardcoat Rod

M106762.

08-05-26 SP

(3X)

9.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S 08/05/26 (48)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/05/26 (28)

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:30 Pm  
320°F  
2:00 Pm

M-L 08/05/26

(3X)

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

SP 08-05-26 (2)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify on inside surface using a permanent fine point marker with the following

TCCA-PDA, Dart Aerospace Ltd.

8/5/26 SP

(3X)



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Drawing Name: WEARPLATE

Job Number: 39313

Part Number: D33193

Job Number:



Seq. #:

Machine Or Operation:

Description :

P/N: D3319-3, B/N: BXXXXX  
For Product Eligibility see PDA05-18  
and Stock  
Location: 496

8/5/26

(3x)  
80

14.0

QC21

FINAL INSPECTION/W/O RELEASE



08/05/27 AJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

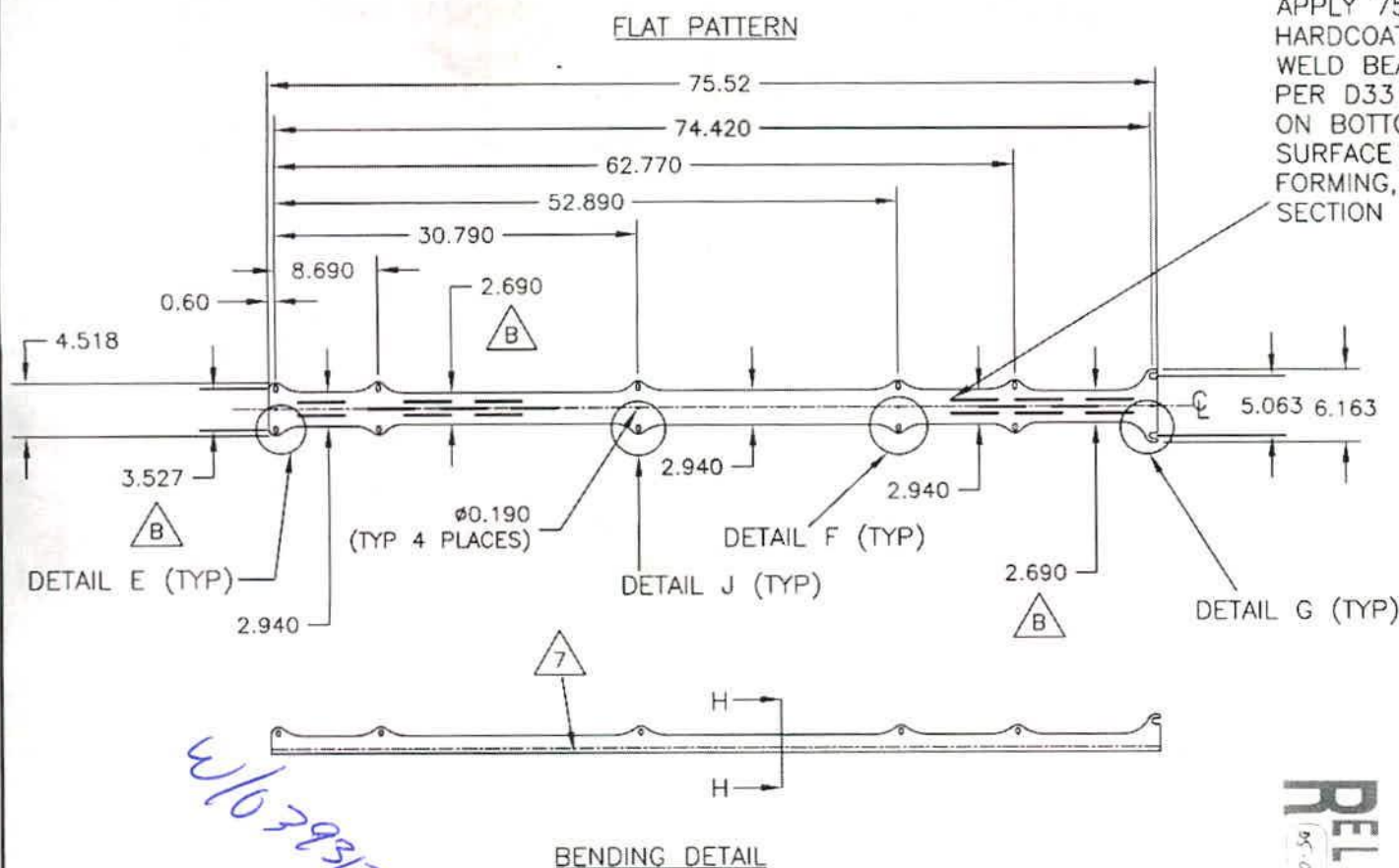


W 08-05-27

**DART**

DESIGN	CHKD	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	DRAWING NO.	HAMKESBURY, ONTARIO, CANADA
DATE		TITLE	REV. B
05.06.06		WEARPLATE	SHEET 2 OF 5
			SCALE
			1:15

APPLY 7560  
HARDCOAT  
WELD BEADS  
PER D3319-3T1  
ON BOTTOM  
SURFACE AFTER  
FORMING, SEE  
SECTION H-H



#### D3319-3 WEARPLATE

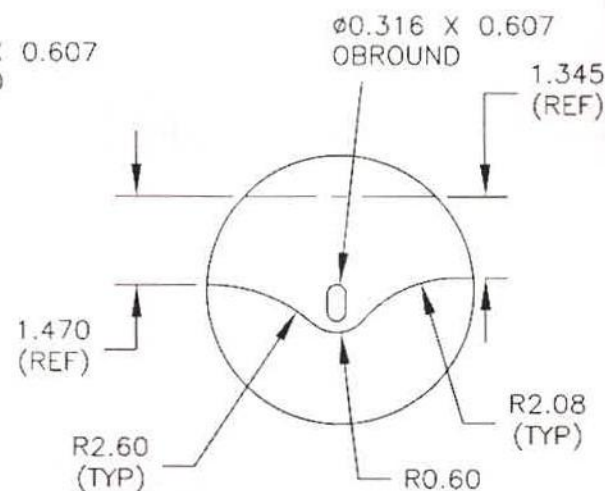
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:  
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-3 B/N BXXXXX,  
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

RELEASED  
05-01-30

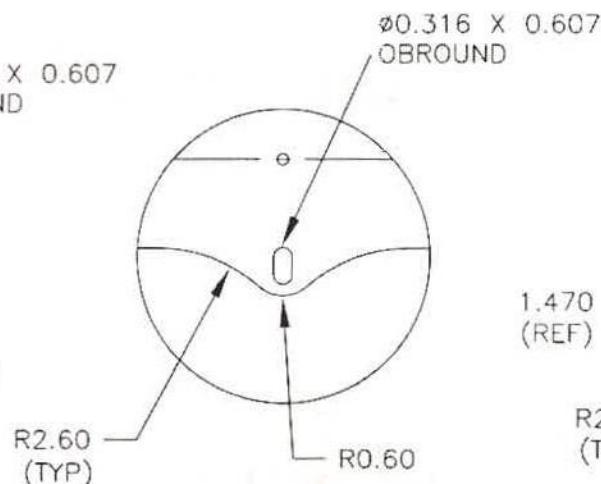
**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA		
CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO.	REV. B	
		D3319	SHEET 5 OF 5	
DATE 05.06.06		TITLE WEARPLATE	SCALE 1:3	

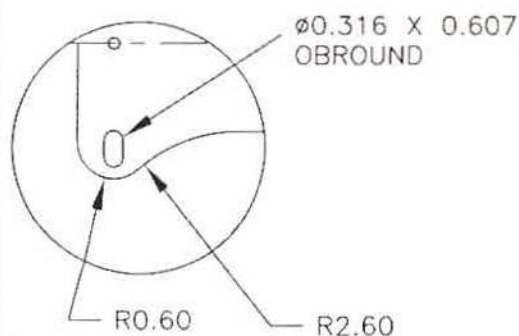
RELEASED



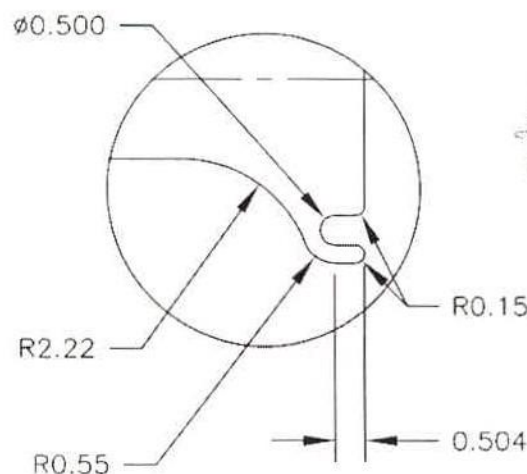
**DETAIL J**



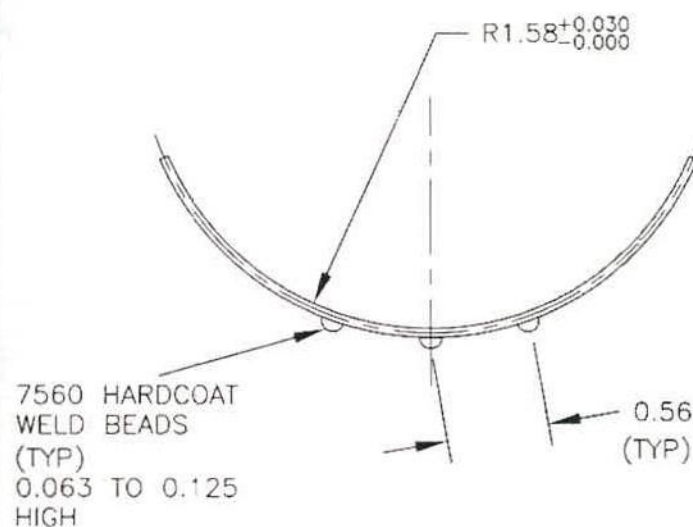
**DETAIL F**



**DETAIL E**



**DETAIL G**



**SECTION H-H  
(SCALE 1:1)**

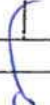
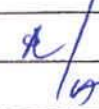


CART AEROSPACE LTD		Work Order: 39313
Description: WEAR PLATE		Part Number: D3319-3
Inspection Dwg: D3319-3 Rev: B		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .190	+ .005 - .001	.190	*			
Ø .316	+ .006 - .001	.316	*			
.607	+ .008 - .001	.608	*			
Ø <del>.500</del>	+ <del>.005 - .001</del>					
Ø .316	+ .006 - .001	.317	*			
<del>.500</del>	+ <del>.008 - .001</del>					
3.527	+/- .016	3.526	*			
4.518	+/- .010	4.516	*			
2.940	+/- .010	2.949	*			
2.690	+/- .010	2.696	*			
5.063	+/- .010	5.063	*			
6.163	+/- .010	6.165	*			
.60	+/- .030	.595	*			
8.690	+/- .010	8.690	*			
30.790	+/- .010	30.790	*			
52.890	+/- .010	52.890	*			
62.770	+/- .010	62.770	*			
74.420	+/- .010	74.420	*			
75.52	+/- .030	75.52	*			

Measured by: HB	Audited by: 	Prototype Approval: 
Date: 8-5-20	Date: 08/05/20	Date: 1/9

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

